

Work Order ID 139965

December 15, 2015 3:01:20 PM

139965

To ship in April 2016.

Page 1

Item ID: D212-725-1-901

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Collective Bell Crank Assembly

Start Date: Mar 11 12/15/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: Mar 31 2/1/2016 Req'd Qty: 6.00

6

Customer:

Reference: Mar 31

Approvals:

Process Plan: SA

Date: 20151215

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4215

A

100

0.00

100

Small Fab

0.05

Small Fab

Memo

****Critical Part,MRB decisions on this part may only be performed by DART DE#02.Any changes to the design,manufacturing process,approved operating enviroment,and design loading spectrum will require a review of the fatigue evaluation for this part*****

1- Install sleeve and bearing as per dwg

2-turn sleeves as required(machining)using DT10064 MADREL

3- Stake bearing as per dwg

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

110

110

QC

Quality Control

DAS
08
9-89

DAS
45
9-89

FF

6

APR 04 2016

DAS
38
9-89

APR 04 2016

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Item ID: D212-725-1-901

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Collective Bell Crank Assembly

Start Date: 12/15/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/1/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.01

Quality Control

MLJ

APR 07 2016

MLJ

APR 07 2016

Picklist Print

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Work Order ID: 139965

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Parent Item: D212-725-1-901

D212-725-1-901

Parent Item Name: Collective Bell Crank Assembly

Start Date: 12/15/2015

Required Date: 2/1/2016

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A now made in house DD 10.02.08 verified by:JLM IPP Rev:B as per ECN10-532 DD 10.04.08 verified by:JLM Ipp Rev:C Added "Critical Part"Note 10-06-02 Verified By:DD
 ****Critical Part,MRB decisions on this part may only be performed by DART DE#02.Any changes to the design,manufacturing process,approved operating enviroment,and design loading spectrum will require a review of the fatigue evaluation for this part*****

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
120-013-3A *120-013-3A* sleeve		Purchased	No			100	Each	7.0000	1	6			DAS 6 8-88
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST565				7					
				113699				7					
120-015-5A *120-015-5A* sleeve		Purchased	No			100	Each	4.0000	1	6			DAS 6 8-88
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST565				4					
				113699				4					
D212-725-1-007 *D212-725-1-007* Collective Bell Crank		Manufactured	No			100	Each	0.0000	1	6			DAS 6 9-88
MS276433 *MS276433* bearing		Purchased	No			100	Each	23.0000	1	6			DAS 6 8-88
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST279				23					
				113673				23					

Picklist Print

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Work Order ID: 139965

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Parent Item: D212-725-1-901

D212-725-1-901

Parent Item Name: Collective Bell Crank Assembly

Start Date: 12/15/2015

Required Date: 2/1/2016

Start Qty: 6.00

Required Qty: 6.00

MS276475

Purchased

No

100

Each

27.0000

1

6

MS276475

bearing

Location

Loc Qty

Loc Code

DAS

ST280

27

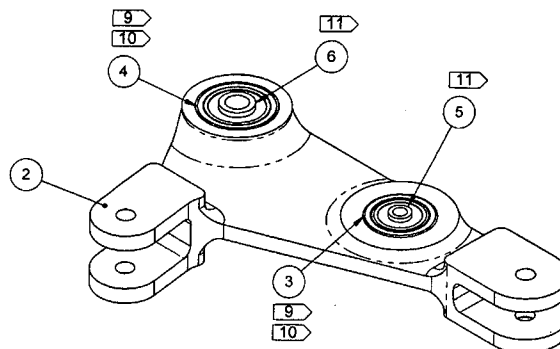
113673

27

6

9-89

ITEM	QTY -901	PART NUMBER	DESCRIPTION
1	X	D212-725-1-901	COLLECTIVE BELLCRANK ASS'Y
2	1	D212-725-1-007	COLLECTIVE BELLCRANK
3	1	120-013-3A	SLEEVE
4	1	120-015-5A	SLEEVE
5	1	MS27643-3	BEARING
6	1	MS27647-5	BEARING



D212-725-1-901 COLLECTIVE BELLCRANK ASSY

CRITICAL PART
MRB DECISIONS ON THIS PART MAY ONLY BE PERFORMED BY DART DE#02. ANY CHANGES TO THE DESIGN, MANUFACTURING PROCESS, APPROVED OPERATING ENVIRONMENT, AND DESIGN LOADING SPECTRUM WILL REQUIRE A REVIEW OF THE FATIGUE EVALUATION FOR THIS PART.

NOTES:

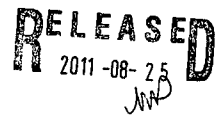
- 1) MATERIAL: N/A
- 2) FINISH: PRIME YELLOW PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.68 lbs
- 8) SWAGE/STAKE PER QSI 002
- 9) SLEEVE ID AND OD MAY BE ADJUSTED TO PROVIDE PROPER FIT
- 10) SLEEVE SHOULD FIT INTO BELLCRANK USING FINGER PRESSURE ONLY
- 11) BEARING SHOULD FIT INTO SLEEVE USING FINGER PRESSURE ONLY

RELEASED
2011-08-25
WAP

20151215

SH 139965

A	NEW ISSUE	RF	11.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4215	SHEET 1 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	COLLECTIVE BELLCRANK	NTS
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LOADING SPECTRUM WILL REQUIRE A REVIEW OF THE FATIGUE
EVALUATION FOR THIS PART.

DESIGN	DC	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4215	REV. A
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		COLLECTIVE BELLCRANK	
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